

Date: Tuesday, 04/07/2006 2:00:44 PM
 User: Linda Lacelle

Process Sheet

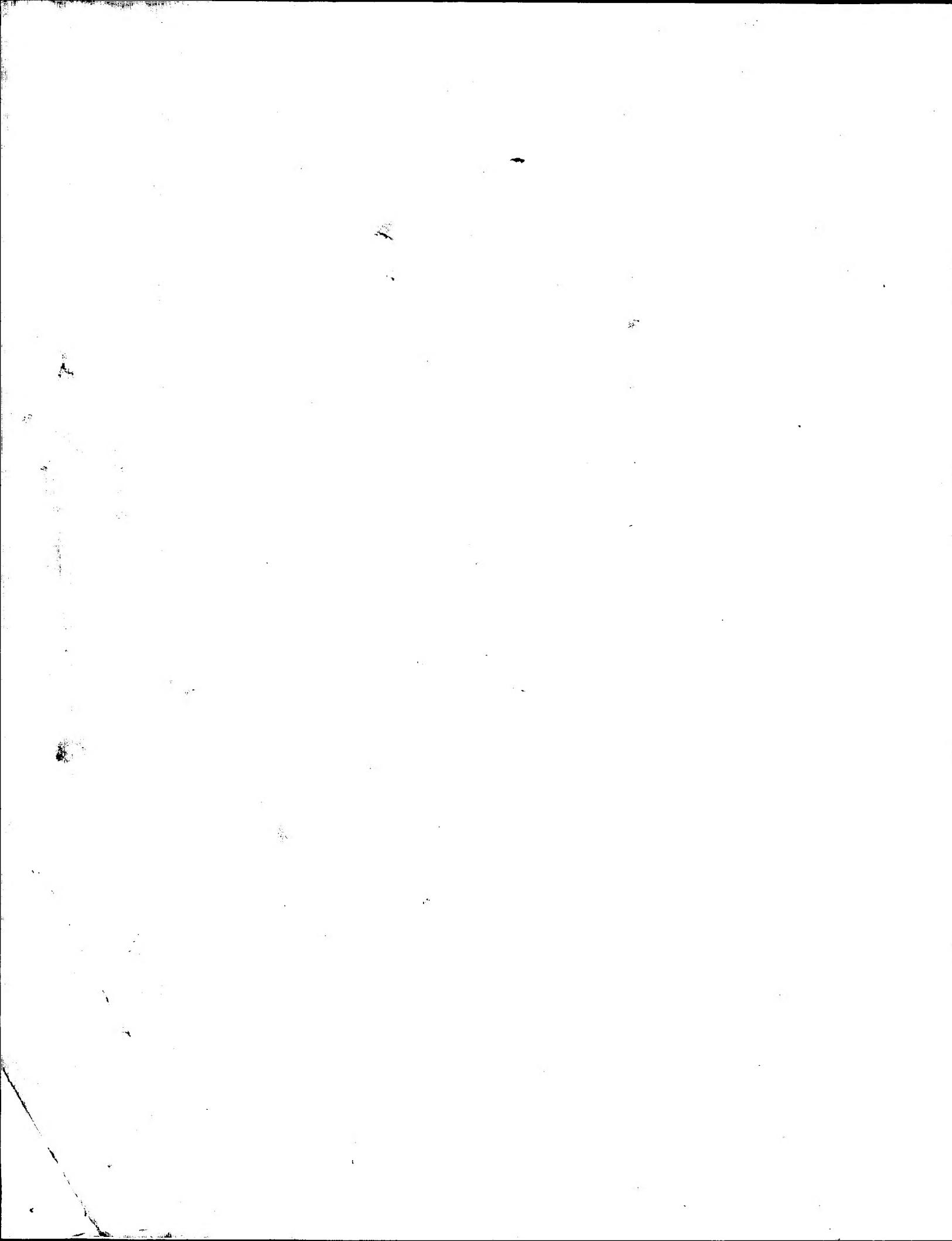
Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STEP SPACER		
Job Number	: 27756D					
Estimate Number	: 10356					
P.O. Number	: N/A		Part Number	: D2279		
This Issue	: 04/07/2006	S.O. No. : N/A	Drawing Number	: D2279 REV D		
Prsh Rev.	: NC		Project Number	: N/A		
First Issue	: 28/06/2006	Type : SMALL /MED FAB	Drawing Revision	: D		
Previous Run	: 25395D		Material	: N/A		
Written By	<u>See Comment Below</u>		Due Date	: 12/07/2006 Qty: 20 Um: Each		
Checked & Approved By	<u>L</u>					
Comment	: Est Rev: A New Issue 05-11-07 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S040	2024-T3 .040 sheet
	Comment: Qty.: 0.1544 sf(s)/Unit Total : 3.0870 sf(s)	
	Material: 2024-T3 sheet (QQ-A-250/4) 0.040" Thick	
	(M2024T3S.040)	
	Identify as D2279	
	Batch: <u>m01411</u> <u>ml 06 07 13</u>	
2.0	WATER JET	FLOW WATER JET
	Comment: FLOW WATER JET	<u>ml 06 07 13</u> (20)
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<u>ml 06 07 13</u> (20)
4.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	<u>J06-07-18</u> (20)
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1	
	Deburr	<u>m.p. 06/07/19</u> (20)



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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 27756D

Part Number: D2279

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form As per Dwg D2279

SB 06/07/20 20

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 06/07/20

20

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 06/07/21 20

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SAD 06/07/21

11.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SB 06/08/01

Job Completion



C 06/08/01

Date: Wednesday, 6/28/2006 4:18:37 PM
User: Kim Johnston

Process Sheet

- Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP SPACER
Job Number	: 27756D	Part Number	: D2279
Estimate Number	: 10356	Drawing Number	: D2279 REV D
P.O. Number	:	Project Number	: N/A
This Issue	: 6/28/2006	Drawing Revision	: D
Prsh Rev.	: NC	Material	:
First Issue	: / /	Due Date	: 7/12/2006
Previous Run	: 25395D	Qty:	20
Written By	:	Um:	Each
Checked & Approved By	: <u>KJ 06 06 09</u>		
Comment	: Est Rev: A New Issue 05-11-07 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M2024T3S040	2024-T3 .040 sheet	
		Comment: Qty.: 0.1544 sf(s)/Unit Total : 3.0870 sf(s) Material: 2024-T3 sheet (QQ-A-250/4) 0.040" Thick (M2024T3S.040) Identify as D2279 Batch: <u>M10147</u>	
2.0	SHEAR / /	SHEAR / / Comment: SHEAR Cut blanks: (4.70" x 4.50") -0.00/+0.020" (grain along 4.50")	
3.0	HAAS	HAAS CNC VERTICAL MACHINING #1 Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio D2279, use stack of 15	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

Date: Wednesday, 6/28/2006 4:18:37 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 27756D

Part Number: D2279

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

7.0 BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form As per Dwg D2279

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

10.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

12.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

 No

DQA:

Date: 04/08/01

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

DART AEROSPACE LTD	Work Order:	27756 D
Description: Step Spacer	Part Number:	D2279
Inspection Dwg: D2279	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>M. M.</u>	Audited by:	<u>J.</u>	Prototype Approval:	N/A
Date:	<u>36 07/13</u>	Date:	<u>06.07.13</u>	Date:	N/A

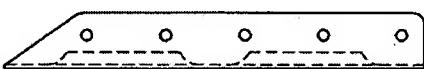
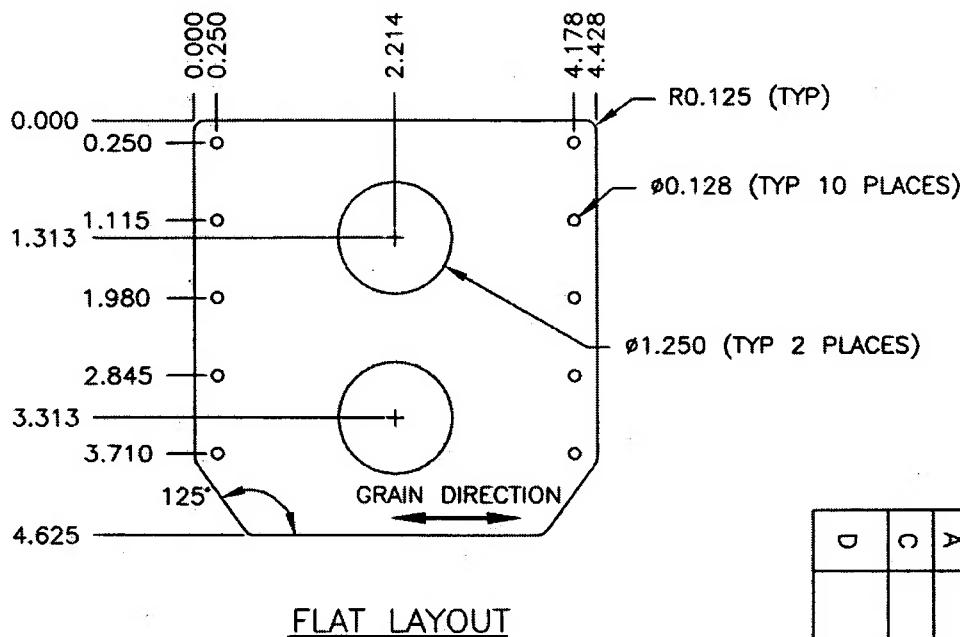
Rev	Date	Change	Revised by	Approved
A	04.10.12	New Issue	P/O D2582	KJ/JLM ✓ <i>[Signature]</i>

DART

DESIGN B/W	DRAWN BY <i>JP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>RE</i>	APPROVED <i>MH</i>	DRAWING NO. D2279
DATE 98.10.05	TITLE STEP SPACER	REV. D SHEET 1 OF 1 SCALE 1:2
A 94.10.13	94.11.15 0.588 WAS 1.607 AND 3.861 WAS 4.881	NEW ISSUE
C 98.10.05	4.428 WAS 4.460, 0.040 WAS 0.032 CHANGES PER TSR A912	
D		

RELEASED
98.10.08 DS

UNDER REVIEW
98.10.15 JP
 DESIGN OK, BUT CHECK WITH
 TB BEFORE MANUFACTURE
 OK *Ch. 109*



MATERIAL: 2024-T3 (QQ-A-250/5) 0.040 THICK
 FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
 TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
 R/T TO
 ENGINEERING
 UNROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER NO. 27756D

